

# Work Order ID 71557

Wednesday, July 06, 2011 1:17:45 PM



Page 1

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 6.00



Customer:

Reference:

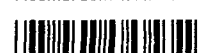
Run Start



Approvals: Process Plan: CL Date: 11/07/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2803	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per FILE D2803-1

0661 5X10

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio FA102

120



QC2- Inspect parts off machine FA1/FAIB

QC

Memo

Quality Control

*Handwritten:* 11 07 19 (A)

*Handwritten:* 11/08/02 4 0

*Handwritten:* 11/08/02 4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71557**

Wednesday, July 06, 2011 1:17:45 PM



Page 2

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/08/02

4

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4

0

11/08/03

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

LX 05 m-l 11/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71557**

Page 3

Wednesday, July 06, 2011 1:17:45 PM

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 178

0.00



Packaging

Memo

0.00

Packaging

11/8/45 (4)

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ce 11/08/0411-08-4  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, July 06, 2011 1:17:43 PM

Work Order ID: 71557

Parent Item: D2803-1

Parent Item Name: Bracket



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A□00.11.06□New Issue□EC□  
 IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM  
 IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.500X10.00 0		Purchased	No			100	f	3.0000	1.9167	12.10547			
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6061-T6 Bar .500 x 10.00

B# 118271

Location  
 MAT004  
 111382

Loc Qty  
 3  
 3

Loc Code

12.2 11/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

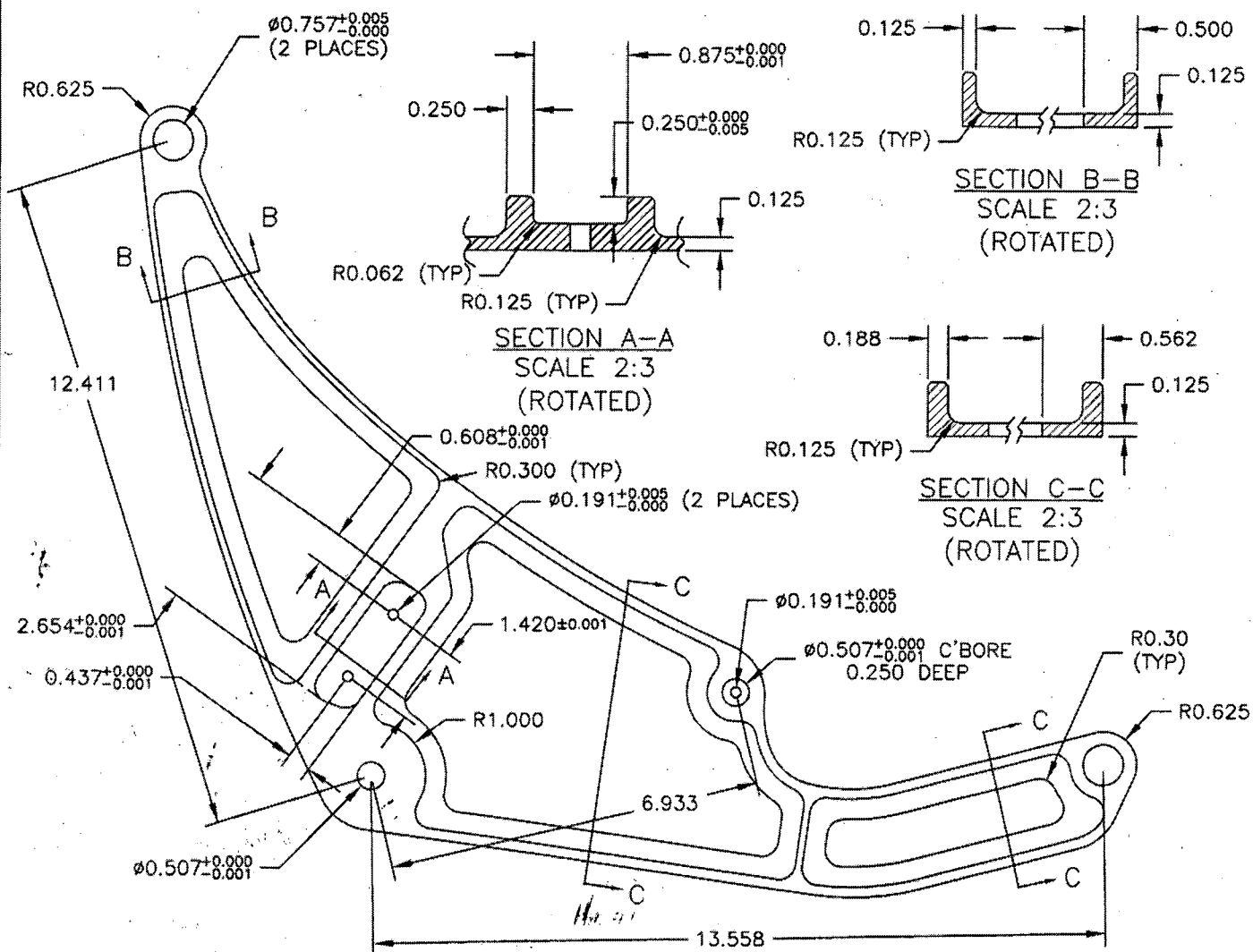


**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22			TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05-03 11

UNCONTROLLED COPY  
SUBJECT TO AMENDMENTWITHOUT NOTICE  
WORK ORDER

NO. 71557

CL1107106

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**



- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

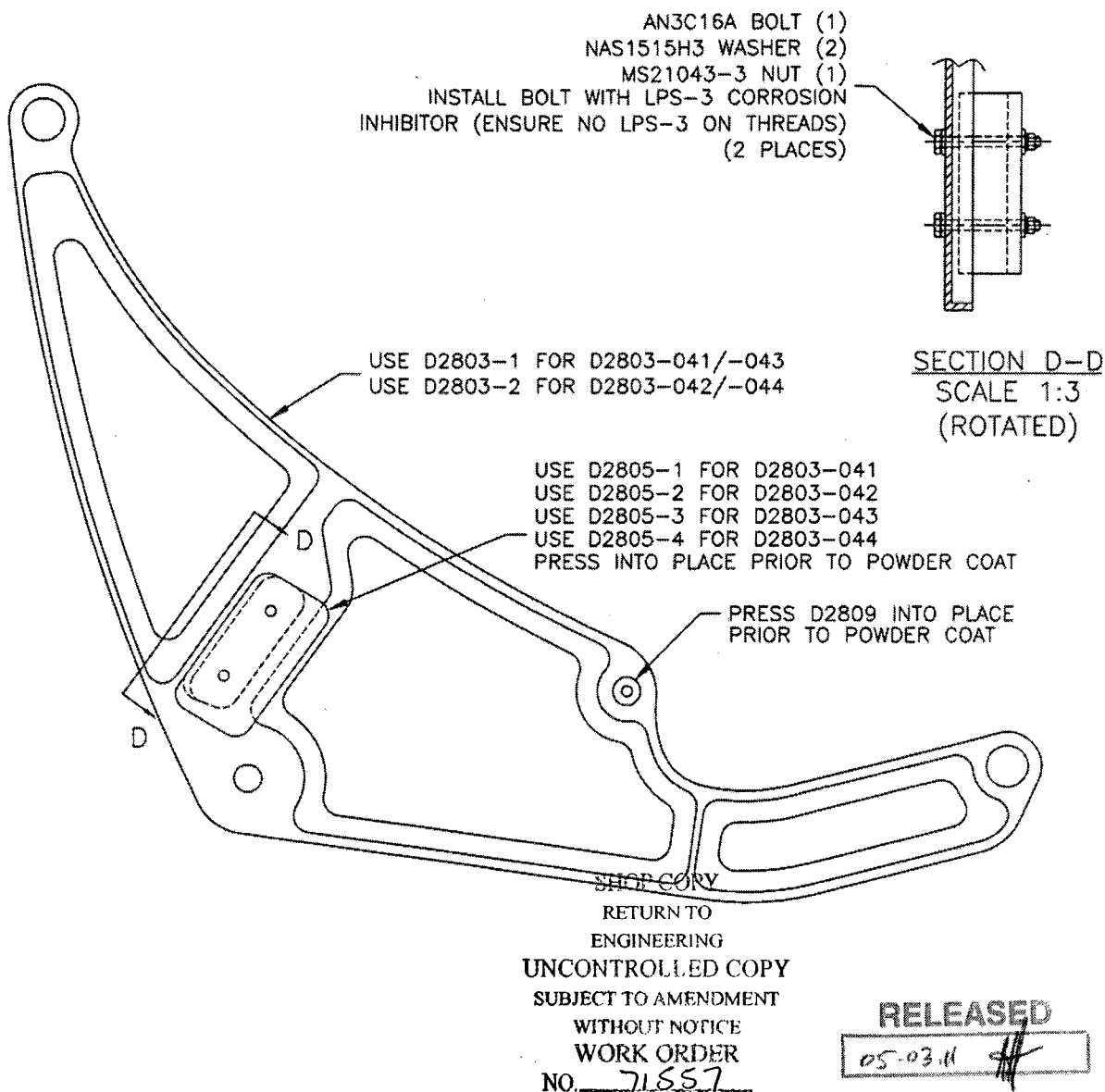
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253  
380

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	71557
<b>Description:</b> Bracket		<b>Part Number:</b>	D2803-1
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.759	✓		Vern JL3	
Ø0.191	+0.005/-0.000	.191	✓		"	
Ø0.507	+0.000/-0.001	.507	✓		DT9526-E	
13.558	+/-0.010	13.558	✓		<del>DT9526-E</del> HG	
Ø0.507	+0.000/-0.001	.5065	✓		DT9526-E	
12.411	+/-0.010		✓		Vern CLKZ	
2.654	+0.000/-0.001	2.6535	✓		Mic JL4	
Ø0.437	+0.000/-0.001	.437	✓		Vern JL3	
1.420	+/-0.001	1.40	✓		"	
6.933	+/-0.010	6.933	✓		Vern CLKZ	
0.250	+/-0.010	.251	✓		Vern JL3	
0.875	+0.000/-0.001	.8745	✓		Mic JL4	
0.250	+0.000/-0.005	.250	✓		Vern JL3	
0.125	+/-0.010	.122	✓		"	
0.125	+/-0.010	.122	✓		"	
0.125	+/-0.010	.125	✓		"	
0.125	+/-0.010	.125	✓		"	
0.500	+/-0.010	.500	✓		"	
0.562	+/-0.010	.563	✓		"	
0.188	+/-0.010	.189	✓		"	

<b>Measured by:</b>	FR/L
<b>Date:</b>	11/07/11-07-28

<b>Audited by:</b>	A.A
<b>Date:</b>	11/08/02

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	AE